Page 1

March 8, 2010 10:00:10 AM D3762-3 Accept Item ID: Setup Start **Revision ID:** Stop Item Name: Tube **Start Qty:** 6.00 \ **Start Date:** 3/08/10 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 3/10/10 **Customer:** Reference: Start Run Tooling: **Approvals: Process Plan:** Date: Date: Stop QC: SPC (Y/N): Date: Date: Operation Reject Sequence ID/ Draw Accept Insp. Set Up/ Draw Plan Reject Qty Qty **Work Center ID** Description Rev. Number Stamp Number Code **Run Hours** Draw Nbr **Revision Nbr** D3762 Rev A 100 0.00 DOOSAN LATHE 0.00 Doosan 1- Turn as per Folio FA749 Rev: / & Dwg D3762 Rev: / Doosan Lathe per dwg D3762 W 10/03/10 110 QC2- Inspect parts off machine FAI/FAIB 0.00 Memo 5/ 10/03/10 Quality Control QC8- Inspect parts - second check 0.00 120

QC

H.A 10/03/10

Quality Control

Memo

Dart Aerospace	e Ltd
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W/O:		WORK ORDER O					
DATE	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-		

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	i:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	STEP Description of NC Section A Initial Chief Eng	**	Corrective Action Section B			Annuaral	A		
STEP		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
					-				
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Sectio		

March 8, 2010 10:00:10 AM

Required Date: 3/10/10

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Item ID:

D3762-3

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Tube

3/08/10

Start Qty: 6.00 Req'd Qty: 6.00

Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

**Tooling:** 

Date:

Start Run

Stop

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Draw

Rev.

Plan

Code

Qty

Accept

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Packaging

Packaging

Memo

Operation

Description

0.00

0.00

Draw

Number

140

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

10/03/11/4/ MF 10-3-11

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	):	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _					

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_\_

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B				Annessal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
					i			
						:		

#### **Picklist Print**

March 8, 2010 10:00:09 AM

Work Order ID: 56753

Parent Item:

Comments:

Item Name

D3762-3

Parent Item Name:

Component Item ID/

Tube

IPP Rev:B

Item ID

IPP Rev:A 08-05-23

Replacement Mfg/

new issue

Purch

DD verified by:ec 08-06-17 rev.A as per dwg DD verified by:EC

No

Bin Primary Item Location Last Location

Route Seq ID 110

Unit of Measure Hand

Qty on 84.1711

Oty To Pick Issued 0.6821

**Start Date: 3/08/10** Start Qty: 6.00

Remaining

Qty

Date Issued

Required Date: 3/10/10

Required Qty: 6.00

Status

M6061T6R1.250 Purchased

6061-T6 Round Bar 1.250

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	84.1711		
108876	9.6		
109733	7.04		
111321	3.3571		
113457	41.804		75ft Sh 10/03/10
113550	20		
18295	2.37		

Page 1

W/O:

DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	):	PAR #: Fault Category: NC	R: Yes	s No <b>DQ</b>	A:	Date: _	

**WORK ORDER CHANGES** 

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
	T	Description of NC		Corrective Action Section B			Ammuousal	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
							-		
		,							

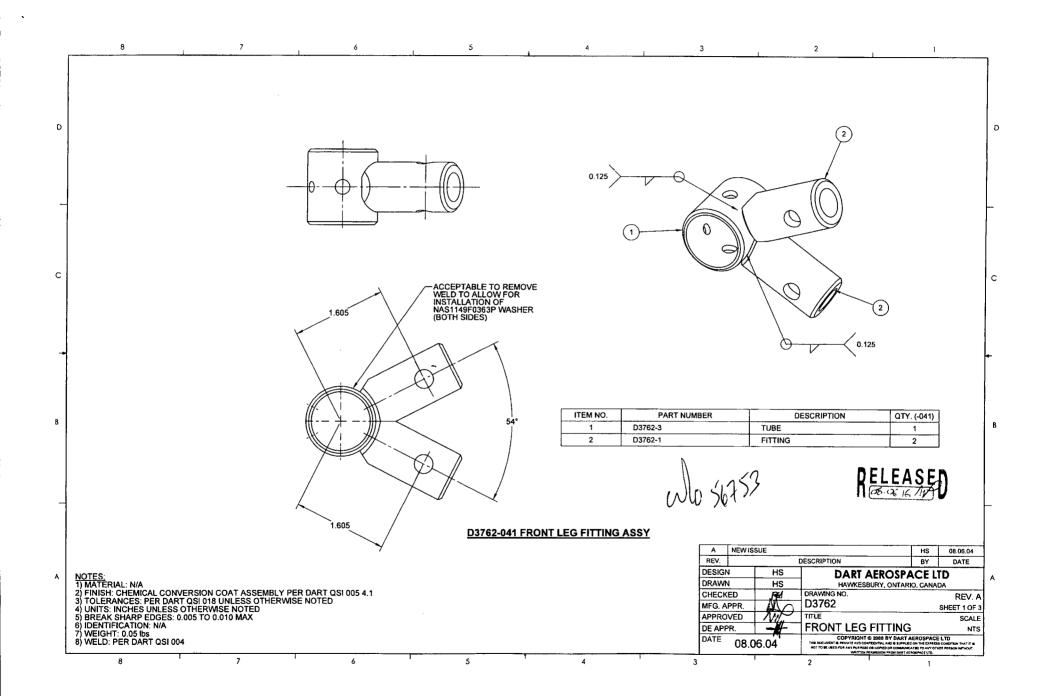
DART AEROSPACE LTD	Work Order: 54753
Description: Tube	Part Number: D3762-3
Inspection Dwg: D3762 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	:le	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.180				
0.05 x 45°	+/-0.030 x +/-0.5°	.OGX45				
1.30	+/-0.030	1.302				
0.65	+/-0.030	.650				
Ø0.257	+0.006/-0.001	0.257				
Ø1.010	+0.010/-0.000	\$1.018				
Ø1.20	+/-0.030	01.204				
63°	+/-0.5°	439				
27°	+/-0.5°	279	/			
27°	+/-0.5°	279				
63°	+/-0.5°	639				

Measured by:	21	Audited by:	H.A	Prototype Approval:	N/A
Date:	10/03/10	Date:	10/03/10	Date:	N/A

Rev	Date	Change	Revised by,	Approved
Α	08.09.04	New Issue	KJ/DD X	



W/O:		WORK ORDER CHANG	GES			,	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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; <b>i</b>							
Part No	):	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification	A	A
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
-								
								ı
. ··.								

D Ø 0.50 C 0.06 X 45° CHAMFER BOTH SIDES -0.05 X 45° CHAMFER Ø0.860<sup>+0.000</sup> Ø0.323 THRU R0.60 --- 1.41 -1.60 ---0.55 D3762-1 FITTING DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R) DRAWN HS ORAWING NO. CHECKED M REV. A (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200 2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.02 lbs D3762 MFG. APPR. SHEET 2 OF 3 APPROVED TITLE SCALE FRONT LEG FITTING DE APPR. NTS COPYRIGHT 6 2008 BY DART AEROSPACE LTD
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160 TO BE USED FOR ANY PRIMARY PRIM DATE 08.06.04

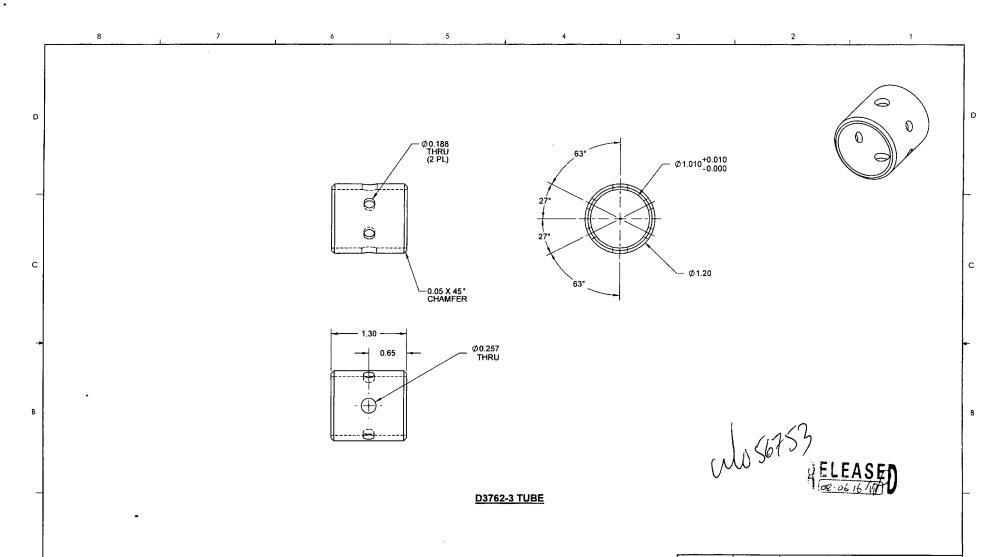
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W/O·

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PF	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>								
Part No	) <b>:</b>	PAR #:	Fault Category:	<b>NCR</b> : Ye	s No <b>DQ</b>	A:	_ Date: _	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC	Corrective Action Section B			Varification	A			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
•										
NOTE: D	  ate & initia	I all entries		· · · · · · · · · · · · · · · · · · ·		<u> </u>				



NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-4
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

8

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3762 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE FRONT LEG FITTING DE APPR. NTS COPYRIGHT 0.008 BY DART AEROSPACE LTD

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